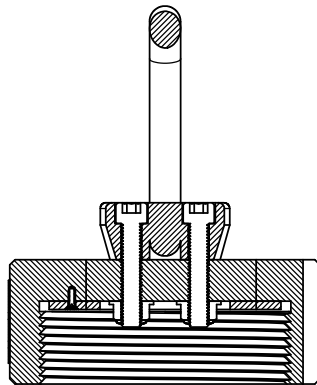
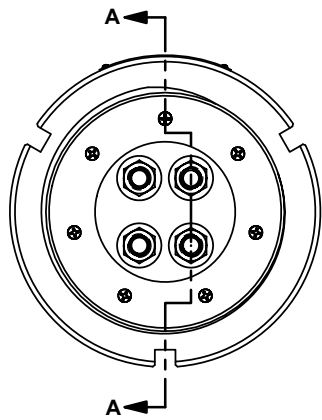


QTY -041	P/N	DESCRIPTION
X	RB 92700-10302-041	LIFT RING ASSEMBLY
1	RB 92700-10302-041-1	RING
1	RB 92700-10302-041-2	PAD
1	RB41011	DART PLACARD
1	29505T240 (OR EQUIV.)	HOIST RING
4	90044A164 (OR EQUIV.)	SOCKET HEAD CAP SCREW
4	90081A077 (OR EQUIV.)	SCREW NAIL
7	90273A194 (OR EQUIV.)	SCREW
4	92018A540 (OR EQUIV.)	LOCKNUT



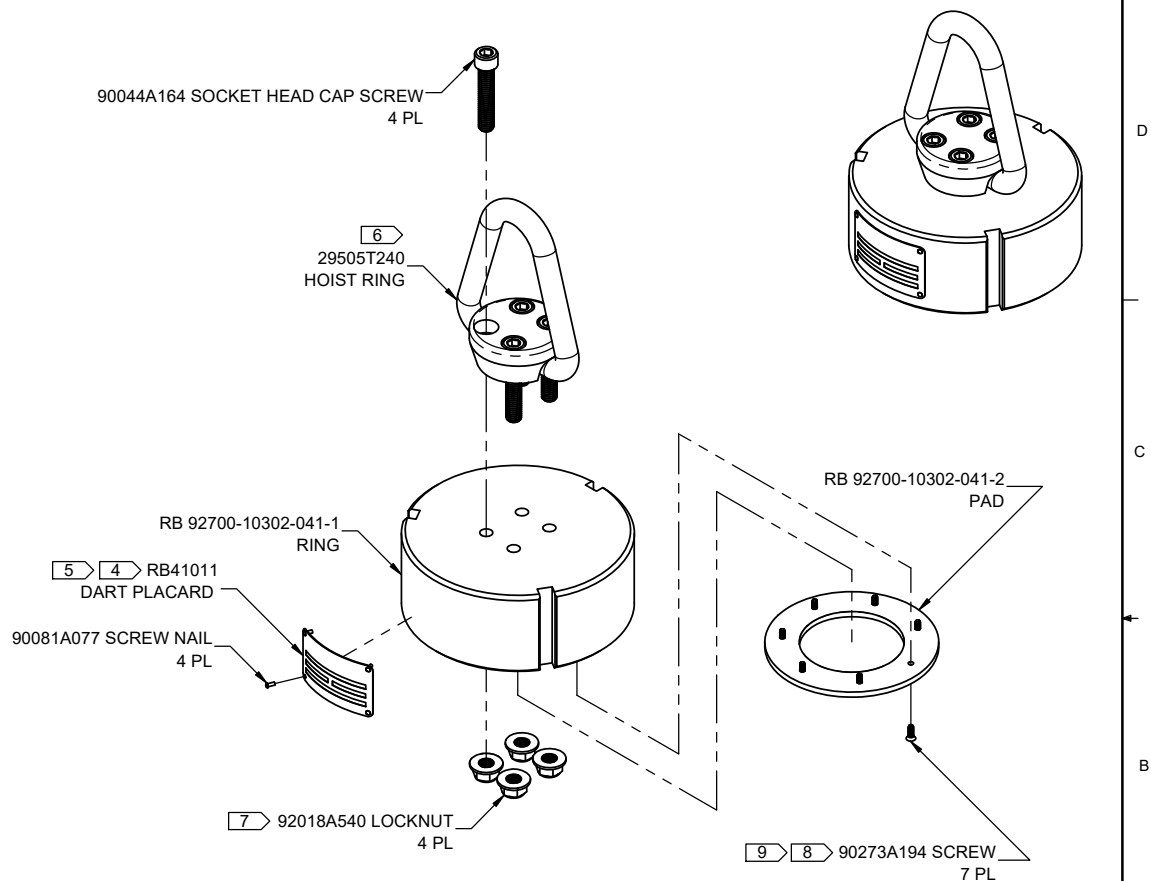
SECTION A-A
(ROTATED 90° CCW)


RB 92700-10302-041 LIFT RING ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: NONE
- 3) FINISH: NONE
- 4) IDENTIFICATION: ENGRAVE THE TOOL P/N, S/N, AND "SAFE WORKING LOAD: 2300 LBS." ON THE DART PLACARD WHERE INDICATED
- 5) FORM TO OUTER DIAMETER OF RB 92700-10302-041-1 PRIOR TO INSTALLATION
- 6) DISCARD INCLUDED SOCKET HEAD CAP SCREWS
- 7) TORQUE TO 55-85 FT-LBS (660-1020 IN-LBS)
- 8) APPLY LOCTITE 263/262 ON THREADS PRIOR TO INSTALLATION
- 9) INSTALL HAND TIGHT

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D	REFER TO REV. C FOR CHANGES MADE IN PREVIOUS REVISIONS REVISED DRAWING TEMPLATE & NOTES		RF	22.09.15		
	-1: 6-5 BUTT-3B-FL WAS 6-5 PUSH-BUTT-3B-FL; UPDATED DETAIL C, UPDATED THREAD NOTES & NOTE 1.					
	REASON: ECR 426					
REV.	DESCRIPTION			BY	DATE	
DESIGN	KPT	UNLESS OTHERWISE NOTED		<div>DART AEROSPACE LTD</div> <div>HAWKESBURY, ONTARIO, CANADA</div>		
DRAWN	RF					
CHECKED	KPT	TOLERANCES: X.X = ±0.1 / ±1.0" X.XX = ±0.01 / ±0.5" X.XXX = ±0.005 / ±0.1" X.XXXX = ±0.0005 / ±0.05" PARALLELISM, ECCENTRICITY, AND SYMMETRY ABOUT ALL CENTER LINES = ±0.005		DRAWING NO. RB 92700-10302-041		REV. D SHEET 1 OF 4
MFG. APPR.	FK					
APPROVED	SAD	BREAK SHARP EDGES: 0.005 - 0.010		TITLE LIFT RING ASSEMBLY		SCALE NTS
DE APPR.	N/A					
DATE	22.09.15			THIRD ANGLE PROJECTION		

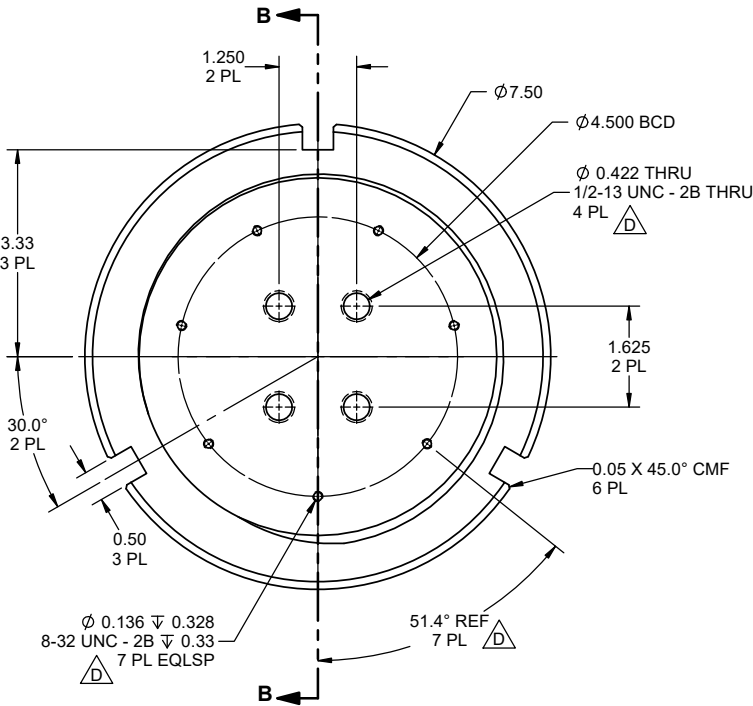
8 7 6 5 4 3 2 1

D

C

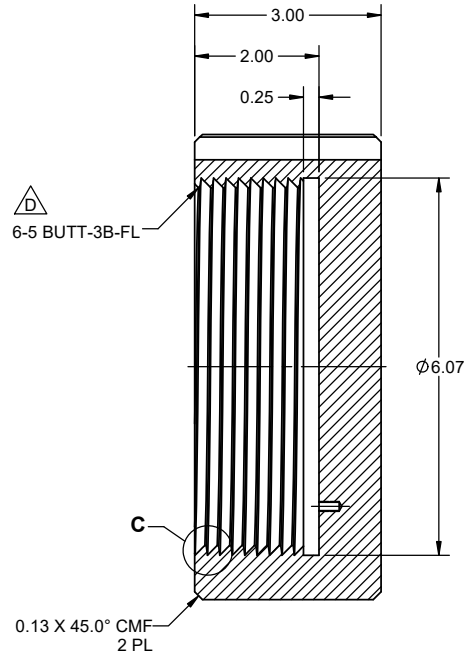
B

A

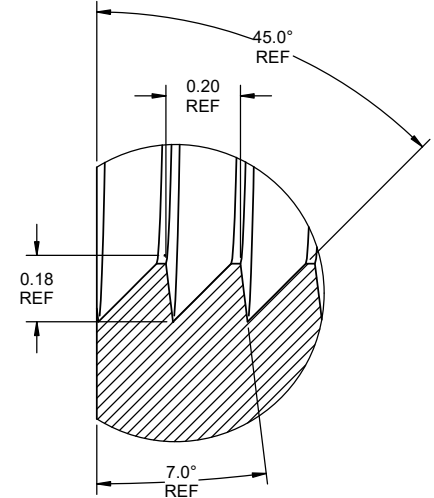


RB 92700-10302-041-1 RING

5



SECTION B-B



DETAIL C

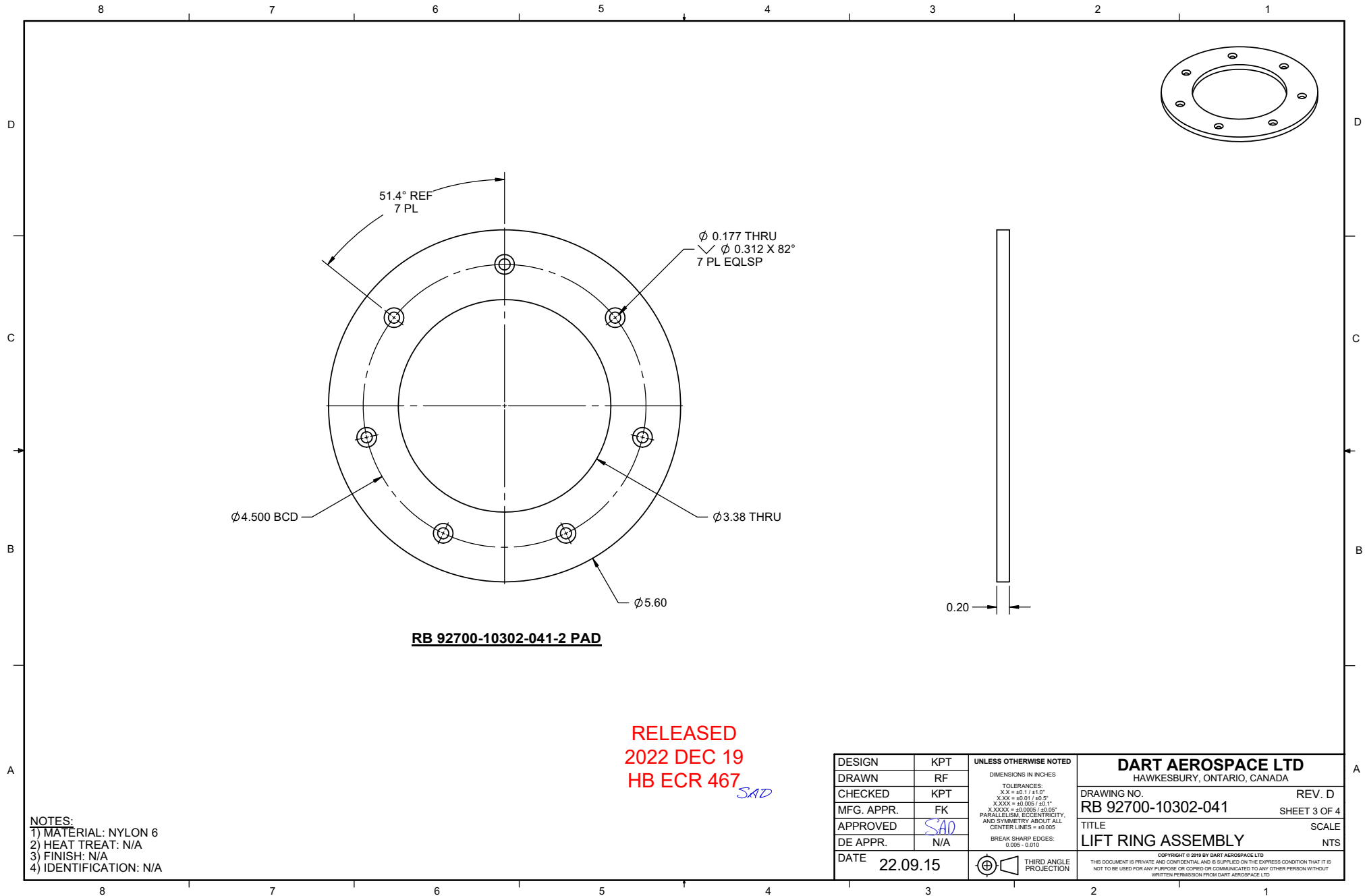
NOTES:

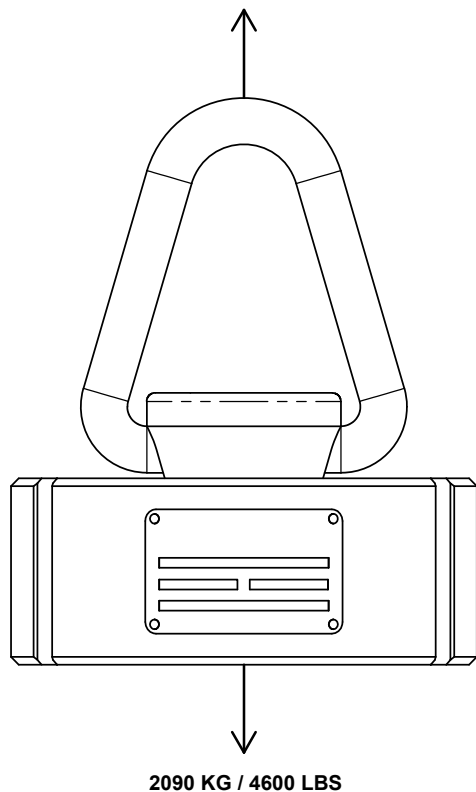
- 1) MATERIAL: AISI 4140/4142 ALLOY STEEL, QUENCHED & TEMPERED, 28-32 HRC
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL/CPC PER MIL-PRF-16173 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) IDENTIFICATION: N/A
- 5) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RB 92700-10302-041-1 REV. D STEP

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SAD

DESIGN	KPT	UNLESS OTHERWISE NOTED		DART AEROSPACE LTD	
DRAWN	RF	DIMENSIONS IN INCHES		HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOLERANCES:		DRAWING NO.	REV. D
MFG. APPR.	FK	X.X = ±0.1 / ±1.0"		RB 92700-10302-041	SHEET 2 OF 4
APPROVED	SAD	X.XX = ±0.01 / ±0.5"		TITLE	SCALE
DE APPR.	N/A	X.XXX = ±0.005 / ±0.1"		LIFT RING ASSEMBLY	NTS
DATE	22.09.15	PARALLELISM, ECCENTRICITY, AND SYMMETRY ABOUT ALL CENTER LINES = ±0.005		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
		BREAK SHARP EDGES: 0.005 - 0.010		THIRD ANGLE PROJECTION	





FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE LIFT RING ASSEMBLY ON AN OVERHEAD LIFTING DEVICE. ATTACH SLING TO AN APPROPRIATE TEST WEIGHT OF 2090 KG / 4600 LBS.
2. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, AND DISTORTIONS
3. REMOVE WEIGHT AND RE-INSPECT SLING, CHECKING FOR STRESS CRACKS, BENDING, AND DISTORTIONS

INSPECTOR: _____

TESTER: _____

S/N: _____

DATE: _____

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2022 DEC 19
HB ECR 467 *SAD*

DESIGN	KPT	<small>UNLESS OTHERWISE NOTED</small> <small>DIMENSIONS IN INCHES</small> <small>TOLERANCES:</small> X.X = $\pm 0.1 / \pm 0.1$ " X.XX = $\pm 0.01 / \pm 0.01$ " X.XXX = $\pm 0.005 / \pm 0.01$ " X.XXXX = $\pm 0.0005 / \pm 0.001$ " <small>PARALLELISM, ECCENTRICITY, AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005</small> <small>BREAK SHARP EDGES:</small> 0.005 - 0.010	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		DRAWING NO.	REV. D
CHECKED	KPT		RB 92700-10302-041	SHEET 4 OF 4
MFG. APPR.	FK		TITLE	SCALE
APPROVED	<i>SAD</i>		LIFT RING ASSEMBLY	NTS
DE APPR.	N/A			
DATE	22.09.15		<small>COPYRIGHT © 2019 BY DART AEROSPACE LTD</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	